

SPLIT

DART AEROSPACE LTD		Work Order:	22253
Description: Sliding Plate		Part Number:	D3333-3
Dwg: D3333 Rev. A PAGE 2		Qty:	20 16
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JH	05.01.17	20 16
2	MV	Cut blanks: 4.000" x 0.500" thick x 9.620" long Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel (M1010-B4.000x00.500) Identify for D3333-3 Batch: M16634	Trl	05/02/07	16
3	MV	Machine as per Folio FA483 and Dwg D3333 Identify as D3333-3	Er/En	05/03/31	8 8
4	QC2	Inspect parts as they come off the CNC machine	En	05/03/31	8
5	QC8	Second check	Er	05.03.031	8
6	MV	Deburr and Grind 45° chamfer on opposite side of pocket along edges as per Dwg D3333	Er	05.03.31	8
7	QC5	Inspect work to Step 6	JLM	05.04.01	8
8	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Ensure to mask threaded holes and sides	ML	05.04.04	8
9	QC3	Inspect Powder Coat	U	05.04.12	4
10	ST	Identify and Stock	CS	05/04/12	4
11	AC	Cost / part: 20.36 62.99	Sac	05.04.12	4
12	DC	Close W/O 20.36 Inspect Level 21	JH	05.04.26	4

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	

RELEASED
05/01/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/03/31	#3	two parts scrap operator error	<i>IS</i> prossur	Destroy	<i>EE</i> 05.04.25	<i>AB</i> 05.04.25	<i>AB</i> 05.04.25	<i>AB</i> 05.04.25

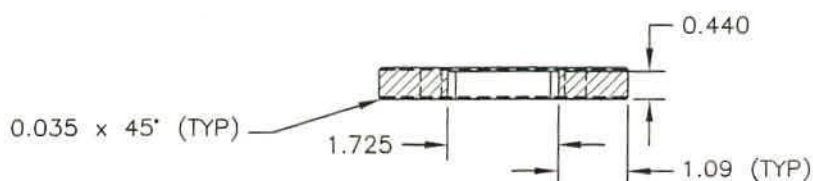
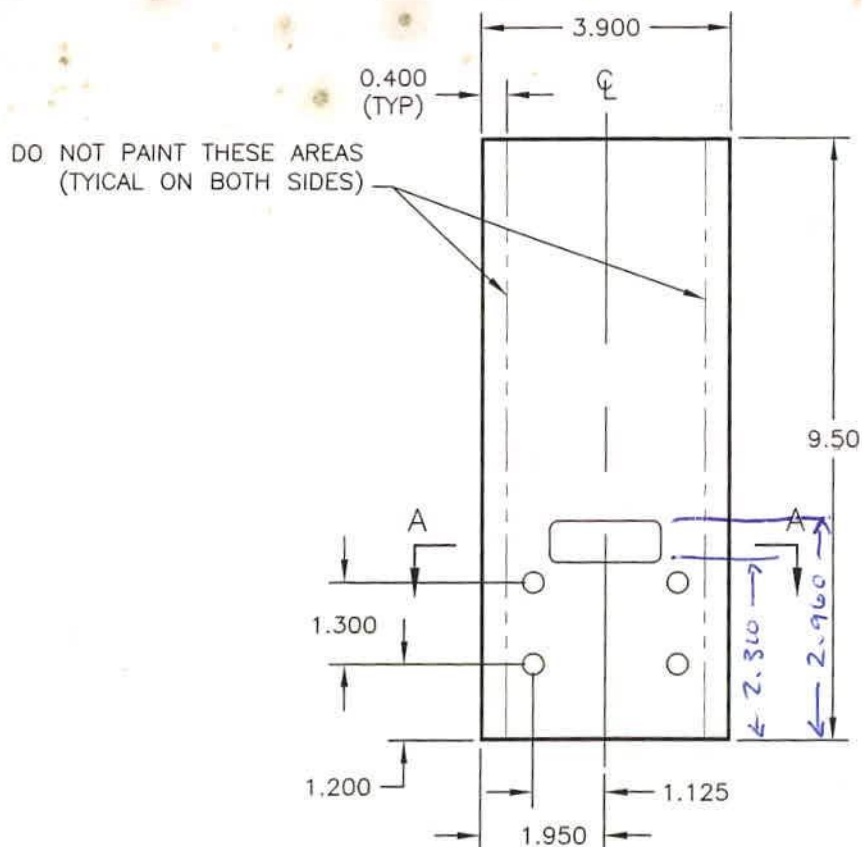
Part No: D3333-3 PAR #: - Fault Category: - NCR: Yes ☒ No ☐ DQA: *AB* Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED	DRAWING NO. D3333	REV. A SHEET 2 OF 3
DATE 04.12.14		TITLE PLATE	SCALE 1:4



SECTION A-A

D3333-3 SLIDING PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 0.50 THICK MILD STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 22253

PRELIMINARY ISSUE

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 17, 2005
01:31 pm

Work Order No : 0022253
Project Name : D3333-3
Project For :
Work Order Type : Main
Main WO Number :
House Part Number : D3333-3
Description : Sliding Plate
Manufactured : Yes
Amount Req'd : 20 4
Amount Done : 0
Start Date :
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

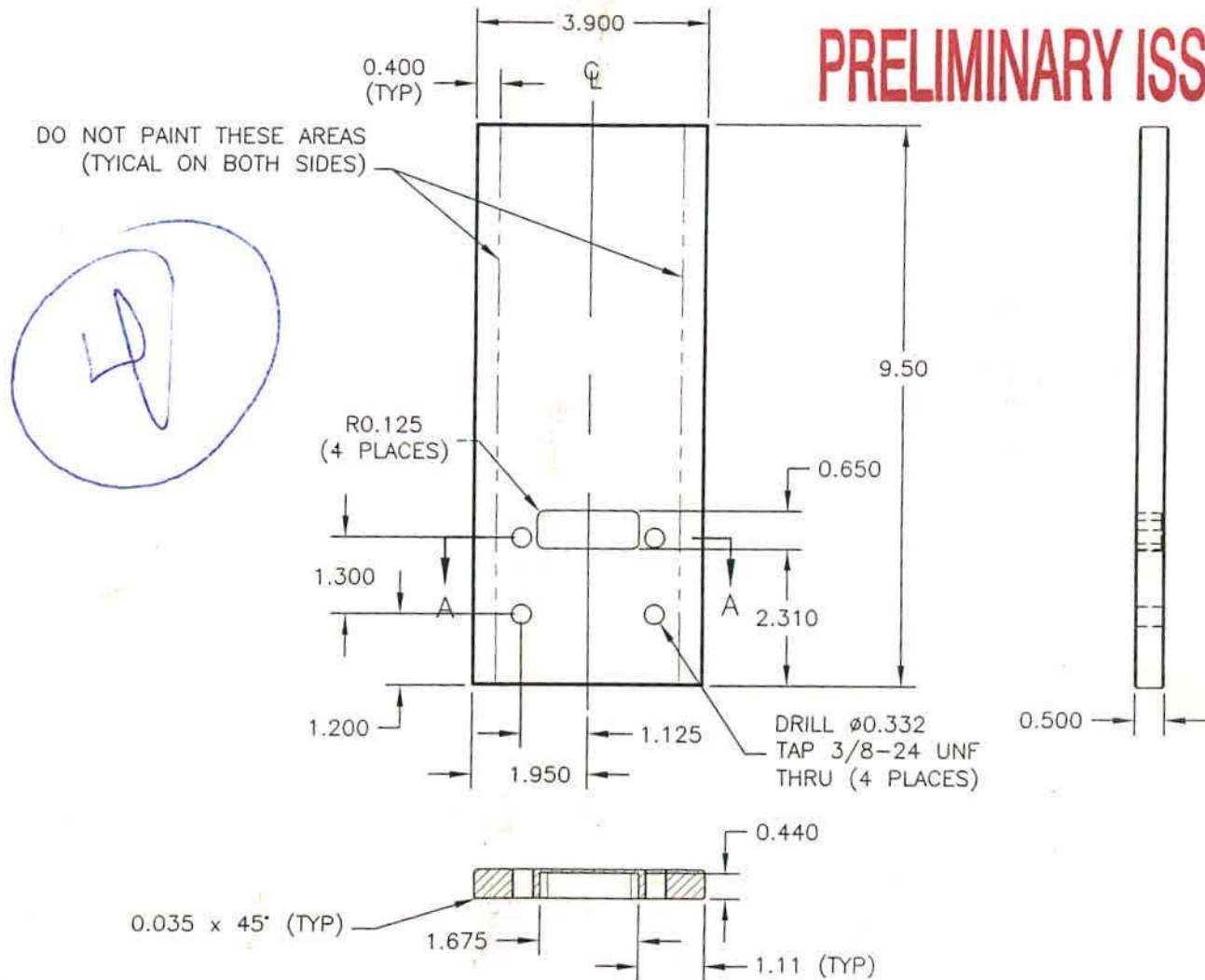
	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

566 19-2

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3333	REV. B SHEET 2 OF 3
DATE 04.12.14		TITLE PLATE	SCALE 1:3
A	04.12.14	NEW ISSUE	
B	05.02.02	TEMP	

PRELIMINARY ISSUE



SECTION A-A

D3333-3 SLIDING PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 0.50 THICK
MILD STEEL (REF. DART SPEC. M1010-B)
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- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD		Work Order:
Description:		Part Number: D333-3
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.900	± 0.01	3.900	✓			
9.50	± 0.03	9.505	✓			
0.650	± 0.01	0.648 0.625	✓	OK		
2.310	± 0.01	2.310	✓	OK		
1.125	"	1.127	✓			
1.950	"	1.945	✓			
1.200	"	1.201	✓			
1.300	± 0.005	1.298	✓			
R.125	± 0.01	R.125	✓			
0.500	"	0.488		✓		OK. #05.02.08
0.440	"	0.437	✓			
1.675	"	1.673 1.672	✓			
0.035 x 45°	"	0.038 x 45°	✓			

Measured by: EC	Audited by: SD	Prototype Approval: TA
Date: 05.02.08	Date: 05.02.08	Date: 05.02.08

Rev A	Date	Change	Revised by	Approved
		New Issue	KJ/JLM	

Work Order:	22253
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Sliding Plate

Part Number:	D3333-3
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Inspected by: D 3333 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

Prototype

Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.900	± 0.010	3.901	✓			
9.50	± 0.030	9.504	✓			
0.650	± 0.010	0.650	✓			
2.310	± 0.010	2.314	✓			
$\phi 0.330$	$+0.005$ -0.000	0.332	✓			
1.950	± 0.010	1.950	✓			
1.125	± 0.010	1.128	✓			
1.200	± 0.010	1.206	✓			
1.300	± 0.010	1.302	✓			
0.400	± 0.010	0.400	✓			
0.500	± 0.010	0.493	✓			Min thickness
0.035 x 45°	± 0.010	0.035 x 45°	✓			
0.440	± 0.010	0.440 0.436				
1.114	± 0.030	1.114				
1.675	± 0.010	1.676				

MEASUREMENTS

Er

246

05/03/30

Audited by:

26

Date:

65103/30

Prototype Approval:

在

Date:

05.04.13

Rev. 10/2018

Change

Revised by

Approved

KJ/JLM